

Work Order ID 50120

July 08, 2009 11:34:52 AM

Page 1

Item ID: D3814-3 Accept Setup Start
Revision ID: A Stop
Item Name: Hinge, Lower Airframe
Start Date: 7/10/2009 Start Qty: 6.00 Cust Item ID:
Required Date: 7/31/2009 Req'd Qty: 6.00 Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3814	Rev A								

100	BAND SAW	0.00				6	0		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 4.75" " long								
110	HAAS CNC VERTICAL MACHINING #1	0.00				6	1		
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA780 Rev: _____ & Dwg D3814 Rev: _____ □2-Deburr per dwg D3814 □3-Finish tapping hole to final depth as per Dwg D3814								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				6	0		
QC	Memo	0.00							
Quality Control									

Y.A 09/08/20

Y.A 09/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3814-3 PAR #: N/A Fault Category: Prod. Eng. Coord NCR: Yes No DQA: W Date: 09.08.28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7 Date: 09.08.28

NCR: 50120		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/08/20	110	3/4 endmill was feeding too fast in program for the thickness of the wall (.130) The wall is crooked and not square.		Program has been modified by J.A. 1 part scrap. Replace B 16391	J.A. 09/08/20	 09/08/25		 09.08.25

NOTE: Date & initial all entries

July 08, 2009 11:34:52 AM

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____



1

Hand Finishing

3209

0.00

\Rightarrow ul 09/08/27

6

⑥

Powder Coating

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

July 08, 2009 11:34:52 AM

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00	BL 09-08-27 (6)						
170	Identify as per dwg & Stock Location: <u>133</u>	0.00							
Packaging Packaging	Memo	0.00	09/08/27 (6)						
180	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00	09/08/27 (6)						

09-8-27

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NOTE: Date & initial all entries

Picklist Print

July 08, 2009 11:34:52 AM

Page 1

Work Order ID: 50120

Parent Item: D3814-3RevA

Parent Item Name: Hinge, Lower Airframe

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			110	f	7.6000	2.4960			

6061-T6 Bar 2.00 x 3.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

16391

7.6

7.6

16391

2.496

ml 08/07/10

W/O:		WORK ORDER CHANGES					
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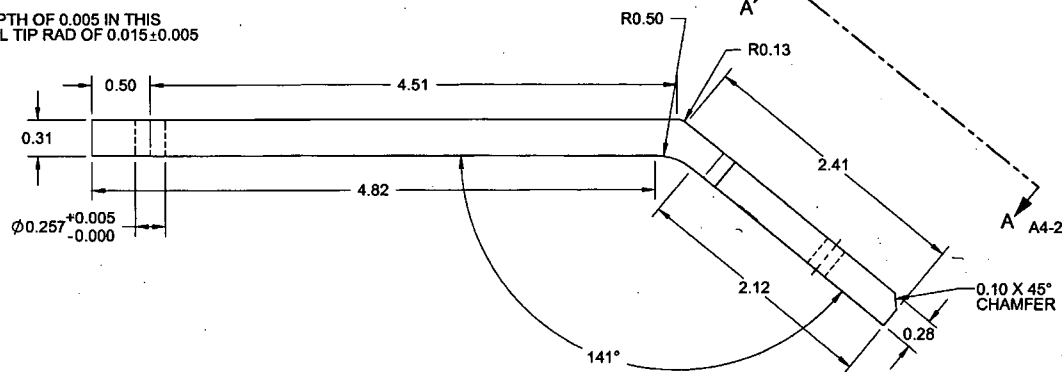
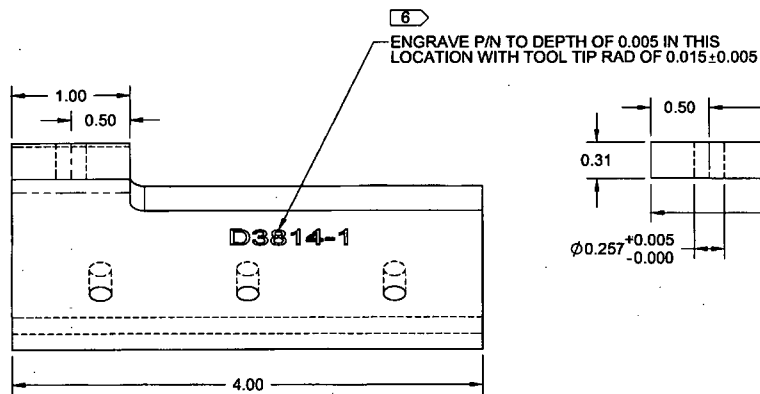
DART AEROSPACE LTD		Work Order:	50120
Description:		Part Number:	D3814-3
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/- .030	3.998	✓			
0.20	+/- .030	0.230	✓			
0.13	+/- .030	0.125	✓			
0.750	+/- .030	0.749	✓			
3.300	+/- .030	3.299	✓			
R0.13	+/- .030	R0.13	✓			
R0.250	+/- .010	R0.250	✓			
1.50	+/- .030	1.497	✓			
1.30	+/- .030	1.30	✓			
0.13	+/- .030	0.125	✓			
0.50	+/- .030	0.501	✓			
Ø 0.257	+ .005 / - .000	Ø 0.259	✓			
R0.50	+/- .030	R0.50	✓			
1.00	+/- .030	0.999	✓			
0.05	+/- .030	0.050	✓			
1.00	+/- .030	1.00	✓			
0.21	+/- .030	0.209	✓			
1.05	+/- .030	1.05	✓			
1.81	+/- .030	1.804	✓			
0.13	+/- .030	0.125	✓			
0.10 X 45°	+/- .030 / +/- 1/2°	0.102 X 45°	✓			
0.75	+/- .030	0.745	✓			
0.310	+/- .030	0.310	✓			
0.75	+/- .030	0.7417	✓			
Measured by:	J.A.	Audited by:	Am	Prototype Approval:		N/A
Date:	J.A. 09/08/21	Date:	09/08/25	Date:		N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3814-1 HINGE, UPPER AIRFRAME

RELEASED
29/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6081-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.36 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		08.11.10
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3814** REV. A
SHEET 1 OF 3
TITLE **HINGE** SCALE NTS

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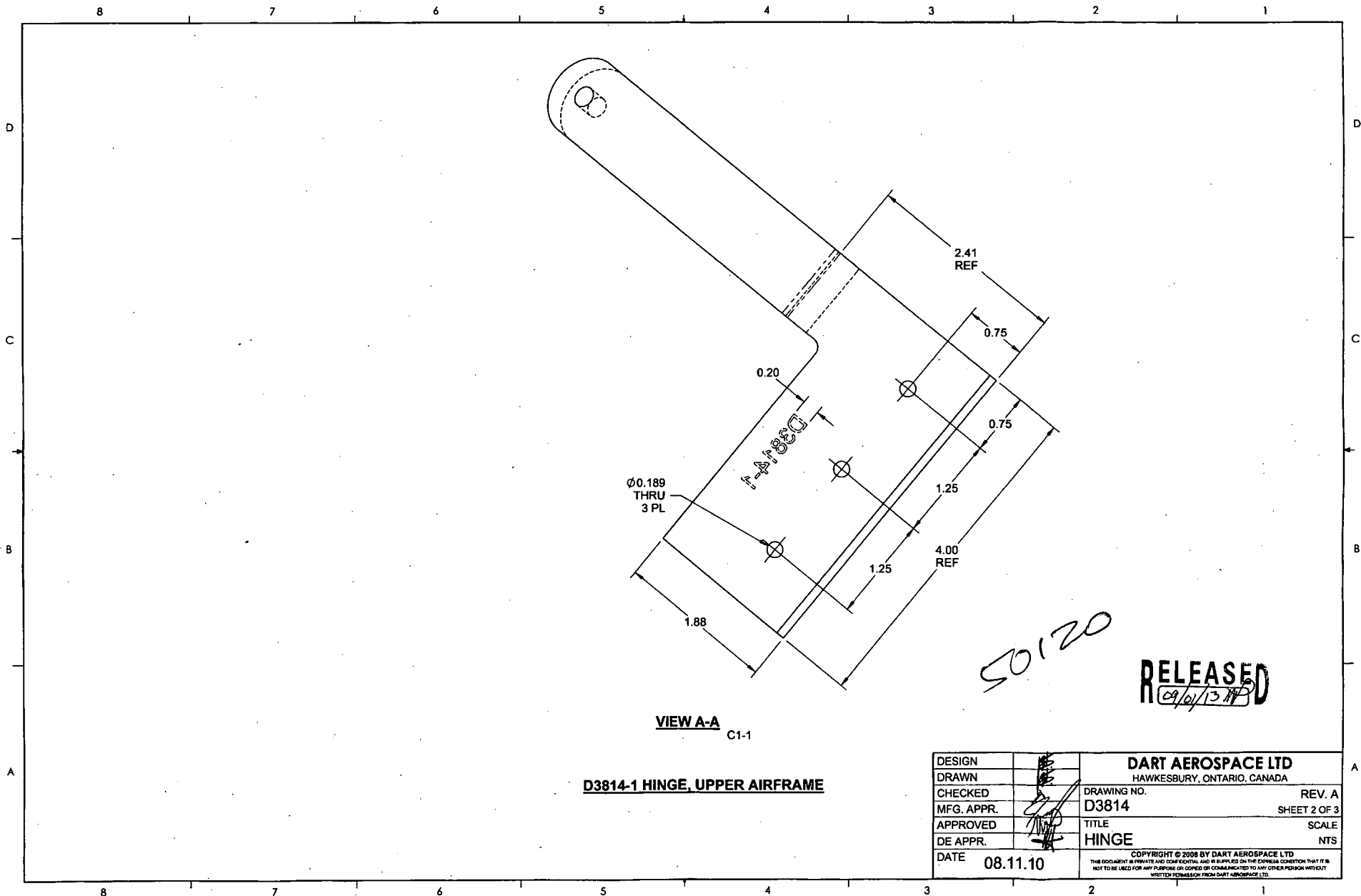
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D3814-1 HINGE, UPPER AIRFRAME

VIEW A-A
C1-1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3814	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	08.11.10	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
09/01/13

50120

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